



**RACE FACE EVOLVE STEM
INSTALLATION INSTRUCTIONS**

Congratulations on your purchase of the Race Face Evolve handlebar stem - good move! The FORGED Evolve stem is a great combination of strength, stiffness and lightweight for any type of mountain bike application. It is important, as with ANY lightweight component, to understand and follow these instructions to ensure the long-lasting performance and safety of this part!

A) COMPATIBILITY:

- 1) Fits 1.125" (28.6mm) fork steer tubes only.
- 2) Fits 1.000" (25.4mm) handlebars only.

B) TOOLS REQUIRED:

- 1) 5mm allen (hex) key.
- 2) Torque Wrench (preferred)

C) STEER TUBE PREPARATION:

1) The Race Face Evolve stem requires 38.0mm (1.50") of exposed steer tube above all headset components and spacers to ensure adequate clamping surface. This is derived from this formula:

Evolve stem "stack height":	40.0mm (1.58")
Subtract headset	
compression gap: (maximum)	- .20mm (0.08")
Total exposed steer tube required:	= 38.0mm (1.50")

NOTE: The Race Face Evolve stem has a relatively low stack height at 40.0mm. This may result in a slightly lower handlebar position than heavy stems with a tall stack height. *Therefore we recommend leaving your steer tube long and adding 2 or 3 spacers (5mm thick), when you are assembling a new bike, or the appropriate amount when you are replacing a tall stack height stem. You can remove them later to suit, and cut the steer tube to the length accordingly, once you have become used to the stem. Remember, you can always cut it shorter, but you can't add material if you cut the steer tube too short!!*

2) Once correct steer tube length has been determined and marked, cut to size. Always follow fork manufacturer's instructions for this process. Make sure a saw blade guide or a tubing cutter is used to ensure a straight cut-off. Sand or file-off all burrs from both the inside and outside of the end of the steer tube as left by the cutting process. File a small chamfer on the outside edge of the steertube. This will assist in the installation of the stem and the headset components.

D) INSTALLATION:

* The Race Face Evolve stem's hardware is pre-lubed and assembled at the factory, therefore disassembly is NOT required for installation.

It is important, however, to familiarize yourself with the various components of the stem to ensure that your stem

assembly is complete and to understand how it works. (See exploded assembly drawing) If any components are missing, contact your dealer immediately do not substitute or attempt installation without all parts shown in diagram.

1) Install all headset components and optional spacers onto the steer tube. Make sure the steer tube is clean and dry (no grease).

2) Loosen the two STEER TUBE CLAMP BOLTS a few turns with your 5mm allen key, so that only a few threads are engaged into the STEM BODY. Check to make sure that the STEER TUBE CLAMP BOLTS have the built-in washers installed.

3) Slide the stem onto the steer tube. This is a snug fit and some back and forth rotation may be required to slide the stem down until it touches the headset spacers. You will note that this will "expand" the steer tube clamp of the stem open slightly at the clamp slot. This is OK.

4) Install the headset's "top cap" and "compression bolt" on top of the stem. Adjust the headset pre-load as per headset manufacturer's specifications, using your 5mm allen key. (Typically until all "play" is removed, but rotation is still smooth)

5) Line stem up straight with front tire, then tighten both STEER TUBE CLAMP BOLTS to 9.0-10.0 ft./lbs. (12.2-13.5 Nm) torque using your 5mm allen key. Alternate back and forth between the two bolts until full torque setting is achieved.

***CAUTION: Do not overtighten STEER TUBE CLAMP BOLTS as damage to the aluminum threads in the stem body may occur. This may inhibit the clamping ability of the stem which may result in loss of control and injury to the rider. If you have damaged (stripped-out) one or both of the threads by over-tightening DO NOT USE THE STEM!**

6) Loosen BAR CLAMP BOLTS and slide your handlebar into the clamp. (Or remove both bolts and the HANDLEBAR CLAMP if you are installing a bar with controls and grips already installed.) Re-install HANDLEBAR CLAMP and BAR CLAMP BOLTS, and tighten bolts to 8.0-9.0 ft/lb. (10.8-12.2 N.m) torque using your 5mm allen key. Alternate back and forth between bolts until full torque setting is achieved. Check to ensure that the gap between the HANDLEBAR CLAMP and the STEM BODY is even between the top and bottom bolts. (approx. 2-3mm).

***CAUTION: Do not overtighten BAR CLAMP BOLTS as damage to the aluminum threads in the stem body may occur. This may inhibit the clamping ability of the stem which may result in loss of control and injury to the rider. If you have damaged (stripped-out) one or both of the threads by over-tightening DO NOT USE THE STEM!**

D) WARNING! Please strictly adhere to the following. Failure to do so could result in pre-mature failure of the part which could affect the rider's control of the bicycle and result in serious injury.

1) Both the STEER TUBE CLAMP BOLTS and BAR CLAMP BOLTS are DN grade 10.9, heat-treated CrMo steel with corrosion resistant chrome plating. Size is M6x20mm. Do not substitute inferior lower strength hardware such as DIN grade 8.8 steel, titanium or aluminum. These materials do not have the strength required for this application. Do not substitute shorter bolt lengths. Full thread engagement is required. If replacement is required, use DIN grade 10.9 or 12.9 M6x20mm hardware only, or see your Race Face dealer for OEM replacement parts.

3) "HEADSET TOP CAP" and "HEADSET COMPRESSION BOLT" must be left in place at all times during operation of the bicycle. These components assist retention of headset adjustment, and act as a "back-up" in the event of loose steer tube clamp bolts, or failure of the steer tube clamp.

E) MAINTENANCE:

1) Check hardware periodically for tightness. Use caution not to over-tighten!

2) Inspect all parts of stem periodically for damage or cracks. This is a good idea with ANY and ALL lightweight aluminum bike parts. This is especially important after any vicious crashes! If you notice anything suspicious, have your Race Face dealer inspect it for you, or replace it.

3) Although not critical to the continuing function of the stem, re-greasing the hardware occasionally wouldn't hurt. (Say during an annual bike tune-up or overhaul). You can apply a light film of grease to all bolt threads, underside of all bolt heads and washers and mating surfaces between steel hardware and aluminum stem components.

** while stem is disassembled, inspect all hardware for wear or damage. If anything is suspect, replace it. It is all inexpensive and available through your Race Face dealer. (see warnings above)

WARRANTY:

1. Our Evolve Stem carries a limited two year warranty. Coverage begins on the user's date of original purchase.

2. This warranty is limited to the original purchaser. Proof of original purchase is required. This can take the form of a photocopy of the original sales receipt. Save your receipts!

3. This warranty covers defects in materials and workmanship.

4. This warranty does not cover defects arising from misuse, abuse, accidents, alterations, lack of main preventative and routine maintenance, or failure to install according to the instructions and proper procedures.